Tuesday, 8/28/2007 3:22:59 PM Kim Johnston User: **Process Sheet** : END PLATE **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 34312 : 10547 **Estimate Number** : D30671 Part Number : N/A P.O. Number . D3067 REV A : 8/28/2007 S.O. No. : N/A **Drawing Number** This Issue : N/A Project Number Prsht Rev. : SMALL /MED FAB First Issue Type **Drawing Revision** :N/A : 32836 Material Previous Run Each : 9/11/2007 **Due Date** Written By Checked & Approved By : Est:03.01.21 Remove step 6 (Deburr) ΚJ Comment Now on Water jet 06-06-16 JLM Est Rev:B **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 5052-H32 .063 Sheet 1.0 M5052H32S063 Comment: Qty.: Total: 10.5000 sf(s) 0.0656 sf(s)/Unit 5052-H32 .063 Sheet Material: 5052-H32 (QQ-A-250/8) ". M5052H32S\_063) or6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: FLOW WATER JET WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3067 Dwg Rev:\_ Prog Rev:\_ 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 4.0 Comment: SECOND CHECK NC BRAKE BRAKE NC Comment: NC BRAKE Bend as per Dwg D3067

## **Dart Aerospace Ltd**

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	.•	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
						;					
Part No		PAR #: Fault Category:	NC	R: Yes	No DQ	A: 🗇	Date: <u>/</u>	919/10			
				QA:	N/C Close	d:	_ Date: _				
NCR:		WORK ORDER NO	N-CONFORMANCI	E (NC	R)						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Varification	Approval Chief Eng			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspecto		
			1.							

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:22:59 PM User: Kim Johnston **Process Sheet** Drawing Name: END PLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 34312 Part Number: D30671 Job Number: Seq. #: Description: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO NEXT STEP PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE U Fre Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				- 1	-					
Part No		PAR #· Fault Category:	NCR: Vac	No DO	۸.	Date:				

Part No:	 PAR #:	Fault Category:	NCR: Ye	s No	DQA:	Date:	
			QA:	N/C C	losed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification		Annroval			
DATE	STEP	Section A		Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Approval Chief Eng	Approval QC Inspector			

NOTE: Date & initial all entries

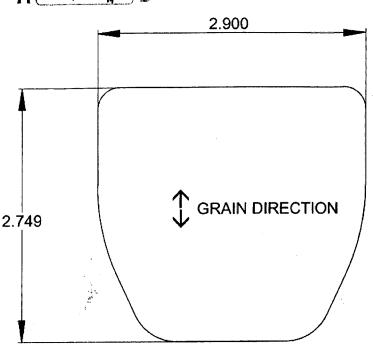
DART AEROSPACE LTD	Work Order:	34312
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067 Rev: A		Page 1 of 1

	FI	RST ARTICLE	INSPEC	TION CH	IECKLIST		
		X First A	rticle [	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
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0.663	1/-0.010	0,057			Ver		
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Measured by:	SAD	Audited by:	8		Prototype App	roval:	N/A
	67/08/31	Date:	<del>                                     </del>	/3/		Date:	N/A
Rev         Date           A         03.10.07	Change New Issue					evised by	Approved

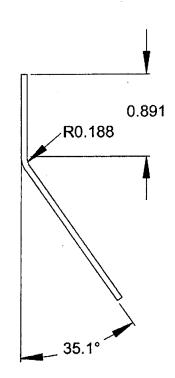


DESIGN	ar	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	7	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1			
DATE	02.0	09.11	END PLATE	SCALE 1:1			
 Α	A 02.09.11		NEW ISSUE				

RELEASED



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK PRDER

**D3067-1 END PLATE** 

1) MACHINE PER DWG FILE "D3067-1.SLDPRT"

2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063) OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063) ALUMINUM SHEET, 0.063 THICK

3) FINISH: NONE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) ALL DIMENSIONS ARE IN INCHES

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